

Work Order ID 61505

Friday, August 27, 2010 3:29:22 PM



Page 1

Item ID: D3401-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Tow Cap Assembly

Start Date: 8/30/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: mf

Date: 10-8-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3401	Rev B								
100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut Blanks 4.20" Long								
110		0.00							
	DOOSAN LATHE								
Doosan	Memo	0.00							
Doosan Lathe	Turn as per Folio FA532 & Dwg D3401								
	Folio Rev: <u>AF</u>								
	Deburr								
	Dwg Rev: <u>2</u>								
120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

10.10.5

10.10.5

10.10.5

Work Order ID 61505

Friday, August 27, 2010 3:29:22 PM

Page 2

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Cust Item ID:




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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 Memo Machine as per Folio FA532 and Dwg D3401 Dwg Rev: <u>B</u> Folio Rev: <u>AA</u> Identify as D3401-1 Deburr & Buff rad as per Dwg D3401	0.00 0.00		SL 11/03/02		(12)			
140  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		SL 11/03/02 SL 11/03/02		12			
150  Small Fab Small Fab	Small Fab Memo Drill and c'sink using DT8782 as per Dwg D3401	0.00 0.00		⇒ m-l 11/03/14		(12X)			

135 QC2
Apr/11.03.02

SL 11/03/02

Work Order ID 61505

Friday, August 27, 2010 3:29:22 PM



Page 3

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Suzuki

12

Quality Control

170

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

12 d 11-3-14

Hand Finishing

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

12 BL 11-3-16

Powder Coating

START TIME:

1:20

OVEN TEMPERATURE:

320°

FINISH TIME:

1:50

Work Order ID 61505

Friday, August 27, 2010 3:29:22 PM

Page 4

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Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 0 11 11/03/30

195

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

12 0 11 11/03/30

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 03 30 12

Work Order ID 61505

Friday, August 27, 2010 3:29:22 PM



Page 5

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Required Date: 9/6/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location: FP-7

0.00



Packaging

Memo

0.00

Packaging

X12 ϕ 11/03/30

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/30

ME

11-03-30

Picklist Print

Friday, August 27, 2010 3:29:21 PM

Page 1

Work Order ID: 61505

Parent Item: D3401-041

Parent Item Name: Tow Cap Assembly

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A 05.09.01 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6R3.500

Purchased

No

200

f

10.2500

0.35

4.421053



6061 RD bar 3.50



10.10.5

Location

Loc Qty

Loc Code

MAT036

10.25

110993

10.25

4.25

NAS1330C3KB116

Purchased

No

100

Each

781.0000

4

48



Insert



11.03.130

Location

Loc Qty

Loc Code

ST276

781

102606

200

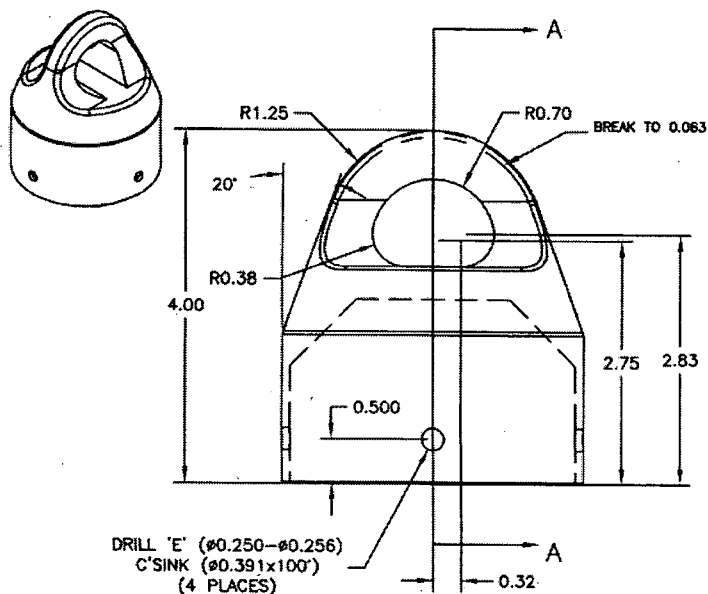
103185

81

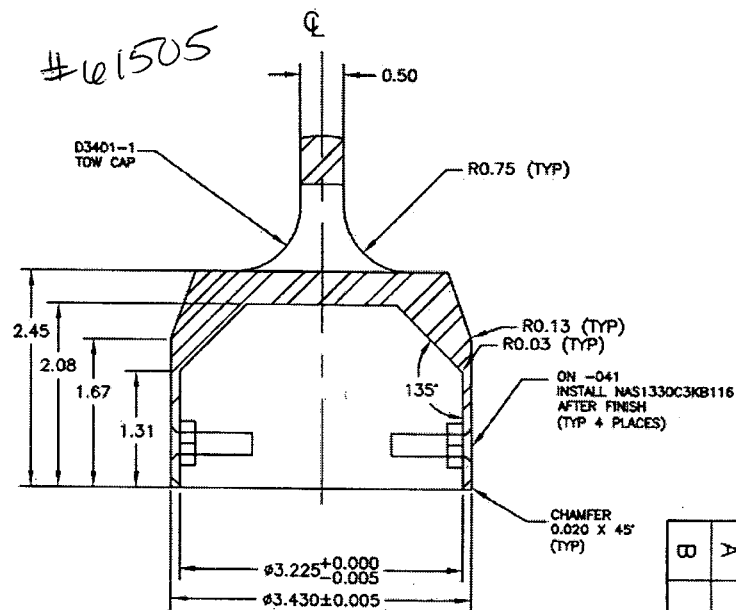
103337

500

X12
X36



D3401-1 TOW CAP



D3401-1/-041 TOW CAP

D3401-1 TOW CAP

- 1) MATERIAL: MAKE FROM ALUMINUM 6061-T6 Ø3.500 ROUND BAR PER QQ-A-225/8 OR AMS-QQ-A-200/8 (REF. DART SPEC M6061T6R3.5000)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3401-041 TOW CAP

- 1) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

D3401-041 TOW CAP PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3401-1	TOW CAP
4	NAS1330C3KB116	INSERT

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
PH	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3401
DATE	TITLE	REV. B
05.06.09	TOW CAP	SHEET 1 OF 1
A	05.02.24	SCALE
B	05.06.09	1:2
	CHAMFER INSIDE, REMOVE RADIUS	

RELEASED
05-08-07

